

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018517**Date Inspected:** 08-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 7E/8E Weld ID: E, Face B – (Grinding)
- 2). OBG East Line Access Penetration Insert Longitudinal Stiff. (LSW) Splice at 5E PP29.5 E2 S (SMAW)
- 3). OBG East Line Access Penetration Insert Longitudinal Stiff. (LSW) Splice at 6E PP46.5 E2 S (SMAW)
- 4). OBG East Line Access Penetration Insert Transverse Stiff. (TS) Splice at 8E PP61.5 E2 SW (SMAW)
- 5). OBG Field Welding of East Line Lifting Rod Access Penetration Inserts (SMAW)
- 6). OBG Lifting Lug Removal – (Oxy-Acetylene Scarfing)

- 1). OBG Field Splice 7E/8E Weld ID: D, Face B – (Grinding)

The QAI periodically observed AB/F approved welder Rory Hogan (ID 3186) assisted by AB/F approved welder Jeremy Dolman (ID 5042) performing grinding to prepare a groove for back welding.

- 2). OBG East Line Access Penetration Insert Longitudinal Stiff. (LSW) Splice at 5E PP29.5 E2 S

The QAI periodically observed AB/F approved welder Xiao Jian Wan (ID 9677) performing welding of fill and cover passes per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position of OBG Field Splice 5E PP29.5 E2 S A-LSE. QC Inspector Fred Von Hoff was present periodically to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1012-3. The welding and flush grinding was completed on the South face of A-LSE and the QAI periodically observed welder 9677 back grinding on the North face. The QAI observed that the work at this location appeared to be in general compliance with contract documents.

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3). OBG East Line Access Penetration Insert Longitudinal Stiff. (LSW) Splice at 6E PP46.5 E2 S

The QAI periodically observed AB/F approved welder Hua Qiang Hwang (ID 2930) performing welding per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position on the OBG East Line Access Penetration Insert LSE Splice at 6E PP46.5 E2 S. QC Inspector John Pagliero was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1012-3. The welding was completed on the South face of A-LSE and the QAI observed that the work at this location appeared to be in general compliance with contract documents.

4). OBG East Line Access Penetration Insert Transverse Stiff. (TS) Splice at 8E PP61.5 E2 SW

The QAI periodically observed AB/F approved welder Wai Kitlai (ID 2953) performing root, fill and cover pass welding per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position on the West face of OBG East Line Access Penetration Insert TS Splice at 8E PP61.5 E2 SW. See photo below. QC Inspector John Pagliero was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1010 rev 1. Cover pass welding was completed on the West face and the QAI periodically observed welder 2953 performing back grinding on the East face. The QAI observed the work at this location appeared to be in general compliance with contract documents.

5). OBG Field Welding of East Line Lifting Rod Access Penetration Inserts (SMAW)

Interior: OBG 4E PP25 E4 welds 1 & 3 (R-1 repairs)

The QAI periodically observed AB/F approved welder Earl Espinoza (ID 5824) performing air carbon arc gouging and grinding of R-1 repair excavated areas at OBG 4E PP25 E4 welds 1 & 3. The QAI subsequently periodically observed welding of fill and cover passes per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position. QC Inspector Fred Von Hoff was periodically present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1001 Repair. Welding was completed and flush grinding was in process. The QAI observed that the work at this location appeared to be in general compliance with contract documents. The QAI observed that there were the following number of excavations at the following weld locations: E4 Weld #1 – 2 excavations, and E4 Weld #3 – 1 excavation.

Interior: OBG 4E PP22 E4 welds 2 & 4 (R-1 repairs)

The QAI periodically observed AB/F approved welder Salvador Sandoval (ID 2202) performing air carbon arc gouging and grinding of R-1 repair excavated areas at OBG 4E PP22 E4 welds 2 & 4. The QAI subsequently periodically observed welding of fill and cover passes per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position. See photo below. QC Inspector Fred Von Hoff was periodically present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1001 Repair. Welding was completed and flush grinding was in process and the QAI observed that the work at this location appeared to be in general compliance with contract documents. The QAI observed that there were the following number of excavations at the following weld locations: E4 Weld #2 – 2 excavations, and E4 Weld #4 – 2 excavations.

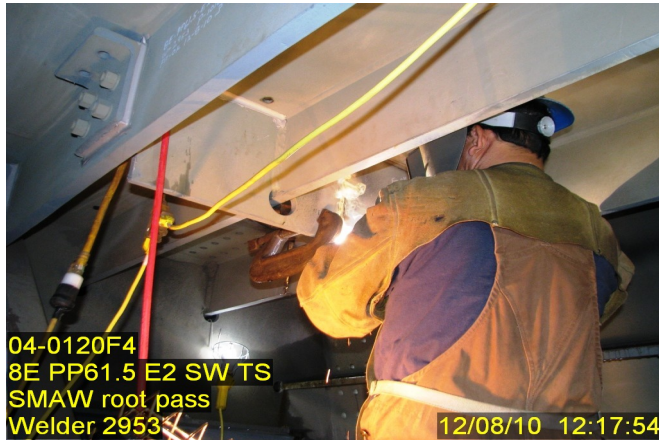
6). OBG Lifting Lug Removal – (Oxy-Acetylene Scarfing)

The QAI periodically observed AB/F approved welder Eric Sparks (ID 3040) and apprentice Ian Murphy performing Oxy-Acetylene Scarfing to remove lifting lugs at the following locations per ABF-RFI-001151R01

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1E PP8.5 E4 Lifting Lug #3, 1E PP9.5 E4 Lifting Lug #3



Summary of Conversations:

Conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities and locations of welds released to the QAI for verification testing.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385 5910, who represents the Office of Structural Materials for your project.

Inspected By: Madison,Bert

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer